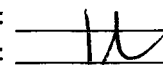
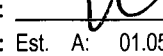


Date: Thursday, 9/11/2008 10:15:38 AM  
 User: Chantal Lavoie

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE BILLET
<b>Job Number</b> :	41963	<b>Part Number</b> :	D6101013
<b>Estimate Number</b> :	10036	<b>Drawing Number</b> :	D6101 REV A
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A
<b>This Issue</b> :	9/11/2008	<b>Drawing Revision</b> :	A
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	
<b>First Issue</b> :	/ /	<b>Due Date</b> :	9/26/2008
<b>Previous Run</b> :	40350	<b>Qty:</b>	15
<b>Written By</b> :		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est. A: 01.05.04 New Issue EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASINGIssue P/O: 7144

a) Description: Aluminum billet

b) 10.100" x 8.250" x 2.50" thick (+0.030 / -0.000)

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 10.100" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

C 208/09/11

(15)

2.0	D6101013P	Saddle billet
-----	-----------	---------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 15.0000 Each(s)  
 Saddle billet

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

10 9/11/09 (15)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

S 08/10/02 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 9/11/2008 10:15:38 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 41963

Part Number: D6101013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*PC 8/10/02*

*(15)*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



*08/10/03*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 08-10-03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

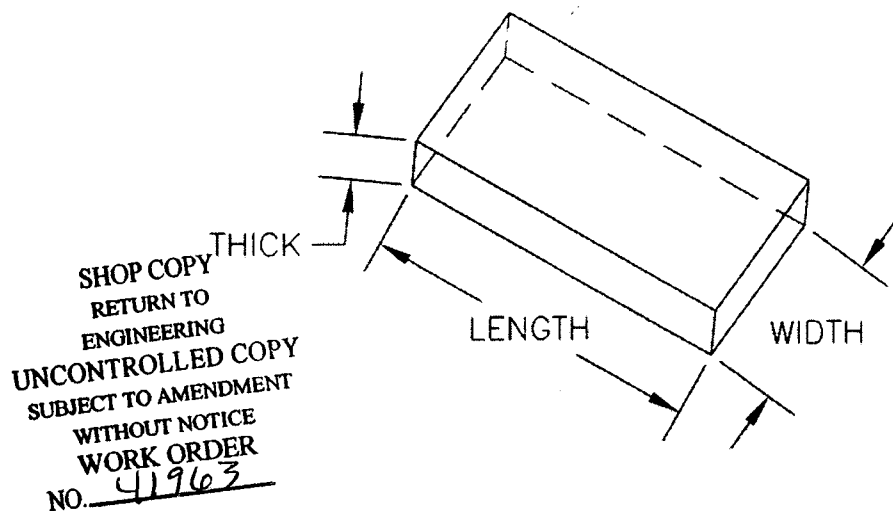
**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>JS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

RELEASED  
01.04.23 *#*



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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SHIP TO:  
A M CASTLE & CO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

**KAISER  
ALUMINUM**

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number  
4122744

SOLD TO:  
AM CASTLE & CO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

CUSTOMER PO NUMBER: 01-42198		WORK PACKAGE:	CUSTOMER PART NUMBER: 6879 A97075-60		SHIP RUN/LOAD ID: 101230/11	GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1061984	LINE ITEM: 1	SHIP DATE: 28-FEB-2008	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE	
WEIGHT SHIPPED: 3596 LB	QUANTITY: 2 PCS EST.	B/L NUMBER: 2016662	GAUGE: 2.5000 IN		WIDTH: 48.500 IN	LENGTH: 144.500 IN	

### Certified Specifications

AMS 4078/RevG  
ASTM B 209/Rev07  
BSS 7055/RevA  
DPS 4.713/RevAH  
GSS16100/RevG

AMS-QQ-A-250/12  
ASTM B 594/Rev06  
CMMP 025/RevR  
EAC MS1011/RevE  
MMS 159/RevN

AMS-STD-2154  
BAC 5439/RevH  
CSTI 006/RevC  
GAMPS 9101/RevB  
PS 21211/RevK

Test Code: 4297

### Test Results

Lot: 436539A1 Cast 149

Drop 39

Ingot 4

(ASTM E8/B557)

Tensile: Temper  
T7351

Dir / # Tests  
LT / 2 (Min:Max)

Ultimate KSI (MPA)  
71.0 : 71.5  
(490 : 493)

Yield KSI (MPA)  
59.6 : 61.2  
(411 : 422)

Elongation %  
10.3 : 10.6

(ASTM E1004)

Conductivity %IACS : 41.1 Min  
(MS/M) : 23.8 Min

41.5 Max  
24.1 Max

(ASTM E1251)

Chemistry:  
Actual

SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
0.10	0.22	1.5	0.02	2.5	0.20	5.7	0.03	0.01	0.01	TOT 0.03

CASTLE METALS CORP.

DATE RCVD 3/4/08

IAC 6879

APPROVED BY

**KAISER  
ALUMINUM**

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

**CERTIFIED TEST REPORT**

Serial Number  
4122744

Lot: 436673A8 Cast 149 Drop 38 Ingot 3

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	71.0 : 71.3 (490 : 492)	59.8 : 60.0 (412 : 414)	10.4 : 10.4

(ASTM E1004)

Conductivity %IACS :	41.0 Min	41.2 Max
(MS/M) :	23.8 Min	23.9 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.10	0.22	1.4	0.02	2.5	0.21	5.8	0.02	0.01	0.01	TOT 0.03

**ALLOY LIMITS**

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

**Aluminum Remainder****TEST NOTES**

Metal represented by this test report was immersion  
ultrasonically tested from one side and meets the Class A  
and Class B requirements of all specifications referenced  
on this test report.

**CERTIFICATION**

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE U.S.A OR CANADA AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

**BILL POYNOR, LABORATORIES SUPERVISOR**

